

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027827**Date Inspected:** 21-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge Manufacturing**Location:** Reedsport, OR**CWI Name:** James Vanek**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** As Noted Below**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QAI) David Gray was at the offsite fabrication facility of American Bridge Manufacturing (ABM) between times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

The QAI met with QAI Jamie Schlarb. The QAI conducted a tour of the facility and introduced him to key ABM personnel.

The QAI witnessed work in progress related to (CCO) 230:

The QAI observed ABM welder Brian Moore (ID# B) complete welding for Suspender Bracket Modifications at the added stiffeners, (reference ABF drawing X451-12A and X451-12B) for fillet weld wrap at ends (Reference RFI ABM-829210-2 and ABF-RFI-002872R00 "Option No. 2") on Suspender Brackets 108W, 108E, 110W and 110E. Quality Control Inspector (QCI) James Vanek was observed visually inspecting the welds. The QAI noted that the welds were in process of having the profile blended by power disc and die grinder to fillet welds previously welded to the end of the shift. The QAI noted that the workmanship herein appears to be in compliance with approved plans and specifications.

The QCM requested the QAI to green tag release SAS Standard Rail Base plates (reference FAB-2706-01 Piece Mark BKX12C (30ea). Material was previously issued OK to Cut. Pieces have been machined, holes tapped (see note 1 on drawings) and blasted to near white finish. Pieces herein appear to be in compliance with approved plans and specifications and were tagged with Lot No. B346-011-12.

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# WELDING INSPECTION REPORT

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## Cable System Split Collars (CCO) 223:

At the direction of Structural Material Representative (SMR) Bahjat Dagher the QAI issued a TL-0015 QUALITY ASSURANCE – INCIDENT REPORT outlining the nature of the discontinuities noted with the split collars.



## Summary of Conversations:

Except as noted above no significant conversations were held on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gray,David	Quality Assurance Inspector
<b>Reviewed By:</b>	Foerder,Mike	QA Reviewer

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